












## Turning Profile Insert

A08-010

The one sided profiled insert is ground totally in one setup using the TTC-clamping system. The operations include the reference faces, sizing the width, pregrinding and finishing the profile as well as the chipbreaker. Quinto automatically considers the distortions given by the turning parameters, chipbreaker- and holderangles.



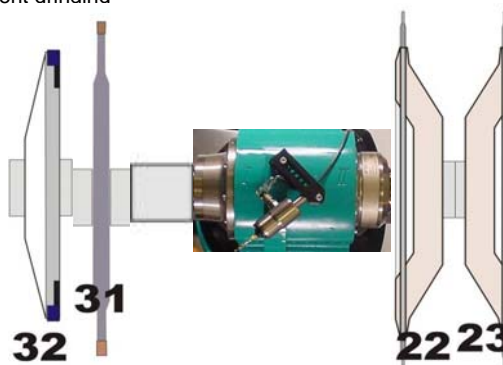
### 1. Cycletime for Production

Tool specifications						
Semitriangle 32x22x5.7						
Material CARBIDE						
Operations						
Feed [mm/Min]	2000	70	20	35	45	10
Power [kW]		1	2	1	1	1
Cutting feed [m/s]		22	22	22	22	22
Used wheels						
Grinding time [s]	10	65	170	95	76	97
Total cycle time	8 Min 33					

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

32 Ø250 12C9 D64  
 31 Ø250 14A1 D64  
 23 Ø300 14EE1 D64  
 22 Ø300 14EE1 D46



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG  
 Control: Fanuc 160i  
 Coolant: Synthetic Oil, pressure 6 - 7 bar  
 Software: Quinto 4.3, DXQ

responsible engineer: OP,13.5.08

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